

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Friday, June 19, 2015 2:32:15 PM

133847

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Square Bracket, Litter Door

Start Date: 6/19/2015 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/19/2015 **Req'd Qty:** 2.00 ***3***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS

27

JUN 23 2015

140 Bend as per dwg

0.00

140

Brake NC

Memo

0.00

Brake NC

DAS

30

9-89

JUN 23 2015

150 QC5- Inspect part completeness to step on W/O

0.00

150

OC

Memo

0.00

Quality Control

DAS
38
9-8

JUN 24 2015

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DQA:

Date: 15/06/30

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

QA Closed:

Date: 15/06/20

Work Order update only ☐

Work Order: B 133847

Part No. 1 4115-3

NCR No. 15-5152

DISPOSITION

Rework ☐Scrap ☒Use-as-is ☐Suspected Unapproved ☐Skid-tube ☐Machining ☐Thermoforming ☐Large Fab ☐

AGAINST DEPARTMENT/PROCESS

Cross tube ☐Small Fab ☒Finishing ☐Composite ☐Water Jet ☐Prod. Eng. Coord. ☐Rec/Store/Packaging ☐Supplier ☐Engineering ☒Quality ☐Other ☐

Date:

15-06-22

Step #:

100

QTY Effective:

1

MRB (QSI042) Approval

A.P.

15.06.24

Description Work Order Deviation

Disposition

(BS-2) PART SHOULD BE "BEND UP".
DRAWING ERROR. A.P. TO CREATE
PAR TO ADDRESS ISSUE.

BEND UP PER MARK UP ON
DWG SH2

Completed By

DAS

30

9-89

JUN 23

2015

Lead hand / Supervisor

Approval Verification

DAS

30

9-89

JUN 23 2015

QC / QA Coordinator

Approval

PD

15-06-24

PAR 15-434

Root Cause

Environment ☒Design ☒Doc/Data ☐Equip/Tooling ☐Handling/Pre ☐Material ☐Internal Transport ☐Tribal Knowledge ☐LOA ☐Substation ☐Past Expiry Date ☐Misidentified ☐No Re-verification ☐Operator ☐Offset/Setup ☐Supplier ☐Training ☐Use for Testing ☐Poor Information ☐Rushing ☐Product Improvement ☐Process Improvement ☐Manufacturing Process ☐Past Due ☐Pressure/Forced ☐Bending ☐Centre Not Concentric ☐Cracks ☐Crimp/Kink/Ripple/Wave ☐Cuffs ☐Crushing ☐Heat Treat ☐Wave/Twist in Tube ☐Marks/Chatter ☐OTHER: ☐

FAULT CATEGORY

Temperature/Cure ☐Set-up ☐BOM/Route ☐Broken/Damage/Defect ☐Inspection Incomplete/Unqualified ☐Contamination ☐Countersink ☐Cut Too Short ☐Instructions Incomplete/Unclear ☐Drill Holes ☐Power Loss/Surge ☐Folio/Program ☐Grain ☐Weld ☐Wrong Stock Pulled ☐Out of Sequence ☐Off-set ☐Mislabeled ☐Fit/Function ☐Misaligned/off center ☐Positioned Wrong ☐Outside Dimensions ☐Over/Under tolerance ☐Part Incorrect ☐Part Lost/Missing ☐Part Moved ☐☒ DrawingFinish ☐Misread ☐Turning Sequence ☐

Work Order ID 133847

Friday, June 19, 2015 2:32:15 PM

133847

Page 3

Item ID: D4115-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Square Bracket, Litter Door
Start Date: 6/19/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/19/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 	0.00						686 92 SVC	JUN 24 2015
160									
Packaging	Memo	0.00				/X			
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00				MLJ			JUN 25 2015
Quality Control									

MLJ JUN 25 2015

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Picklist Print

Friday, June 19, 2015 2:32:19 PM

Page 1

Work Order ID: 133847

133847

Parent Item: D4115-3

D4115-3

Parent Item Name: Square Bracket, Litter Door

Start Date: 6/19/2015

Required Date: 6/19/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev:A 10.09.24 new issue DD verf:EC
10.12.03 as per dwg rev.B DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S14GA

Purchased

No

100

sf

126.1000

0.0185

1

M304S14GA

Jm 15-6-22

304SS sheet .080

Location

Loc Qty

Loc Code

MAT019

126.1

M126075

25.5

M129972

100.6

29972

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : ☐					

DQA: _____ Date: _____

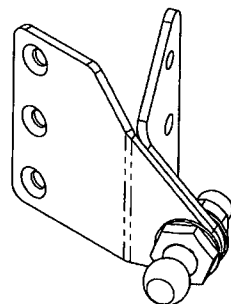


WORK ORDER NON-CONFORMANCE / UPDATE

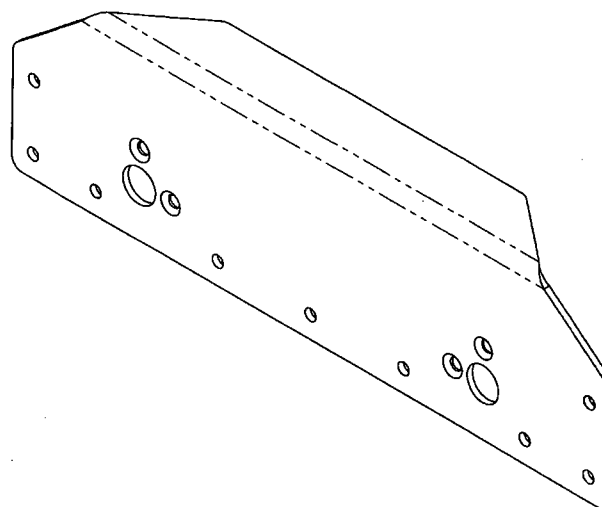
QA Closed: _____ Date: _____

Work Order update only ☐

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D4115-041 LITTER DOOR BRACKET ASSY



D4115-5 BRACKET, LITTER DOOR

SHOP COPY

WORK ORDER
NO. 133847 ML5
1506-19

RELEASED
2010-11-30
M

B	MATERIAL THK CHANGED FROM 0.063 TO 0.080	JPH	10.11.17
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4115	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LITTER DOOR BRACKET	NTS
DATE	10.11.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



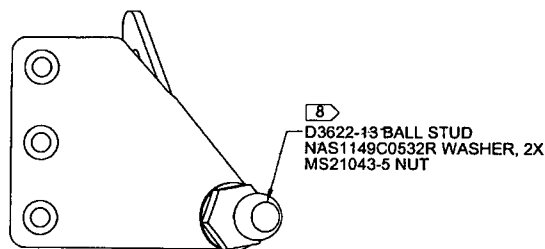
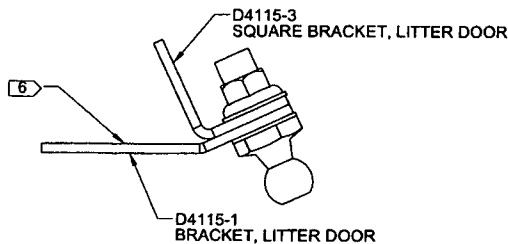
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

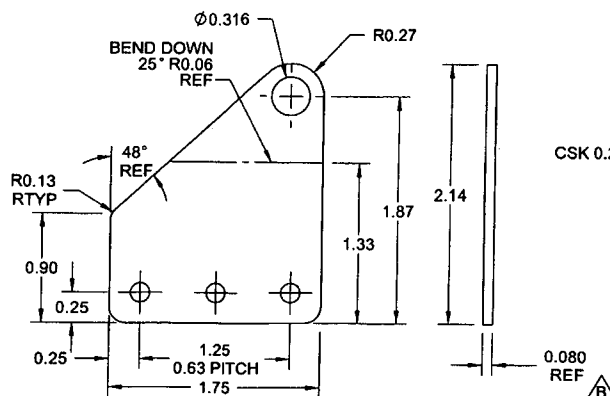
Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

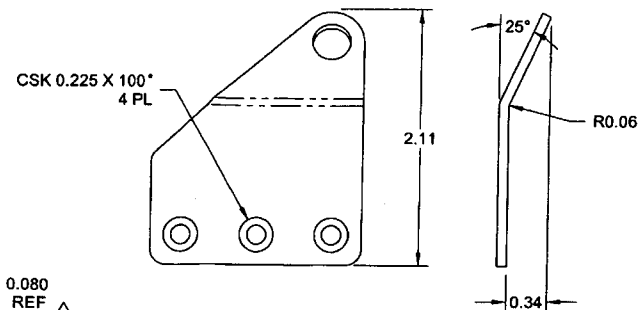
Qty -041	Part Number	Description
	D4115-041	LITTER DOOR BRACKET ASSY
1	D4115-1	BRACKET, LITTER DOOR
1	D4115-3	SQUARE BRACKET, LITTER DOOR
1	D3622-13	BALL STUD
2	NAS1149C0532R	WASHER
1	MS21043-5	NUT



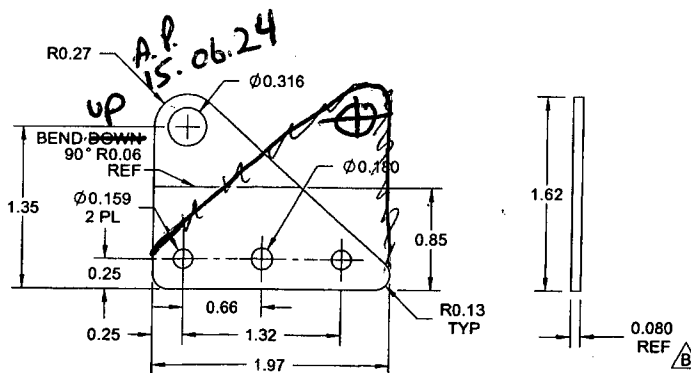
D4115-041 LITTER DOOR BRACKET ASSY



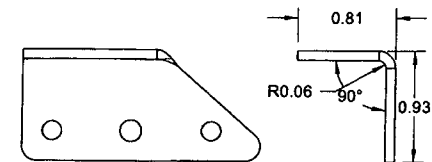
D4115-1F FLAT PATTERN, BRACKET, LITTER DOOR



**D4115-1 BRACKET, LITTER DOOR
(MAKE FROM D4115-1F)**



D4115-3F FLAT PATTERN, SQUARE BRACKET, LITTER DOOR

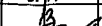


**D4115-3 SQUARE BRACKET, LITTER DOOR
(MAKE FROM D4115-3F)**

NOTES:

- 1) MATERIAL -1F & -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.080 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S14GA OR M303S14GA
-1: MAKE FROM D4115-1F.
-3: MAKE FROM D4115-3F.

- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -041: IDENT P/N D4115-041 & B/N PER QSI 044 6.1
- 7) WEIGHT -041: 0.12 lbs
- 8) TORQUE TO 15 POUND INCH.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4115	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LITTER DOOR BRACKET	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-11-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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